



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7501
Job Sheet 172052



Part No: 647.7501

Job Qty: 1 ea

Part Name: Lower Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time		
					hrs	Hrs				
90	Start up Operation	1 Ea		2/22/18	0.00	0.00	Start Up Stores/Pkg-1			DAS FEB 12 2018
110	Packaging	1 pcs		2/22/18	0.00	0.00	Packaging1-1			DAS FEB 12 2018
120	Small Fab	1 pcs		2/23/18	0.00	1.28	Small Fab-1			DAS FEB 12 2018
130	QC	1 pcs		2/23/18	0.00	0.00	QC5			DAS FEB 12 2018
140	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging3-1			DAS FEB 12 2018
150	QC21-SA	1 Ea		2/23/18	0.00	0.00	QC21			DAS FEB 12 2018

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.
Descriptions: 140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015	Blade	2 Ea (2 ea)	90-Start up Operation	
647.7601	Lower Deflector Assembly	1 Ea (1 ea)	90-Start up Operation	
647.7810	Bracket A	1 Ea (1 ea)	90-Start up Operation	
647.7811	Bracket B	1 Ea (1 ea)	90-Start up Operation	
647.7813	Center Plate, Lower	1 Ea (1 ea)	90-Start up Operation	
647.7814	Fwd Bracket	1 Ea (1 ea)	90-Start up Operation	
647.7815	Fwd Bracket	1 Ea (1 ea)	90-Start up Operation	
647.7816	Aft Bracket	1 Ea (1 ea)	90-Start up Operation	
647.7817	Aft Bracket	1 Ea (1 ea)	90-Start up Operation	
MS21042-08	Use Ms21042L08	13 Ea (13 ea)	90-Start up Operation	
MS21042-3	Nut	3 Ea (3 ea)	90-Start up Operation	
MS27039-08-19	Screw	7 Ea (7 ea)	90-Start up Operation	
MS27039-08-24	Screw (MS27039-0824)	6 Ea (6 ea)	90-Start up Operation	
MS27039-1-19	Screw	3 Ea (3 ea)	90-Start up Operation	
NAS1149F0332P	Washer	6 Ea (6 ea)	90-Start up Operation	
NAS1149FN832P	Washer	26 Ea (26 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3015	2	4	0
	647.7601	1	1	0
	647.7810	1	3	0
	647.7811	1	7	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Suspect ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐

Date: _____	Step #: _____	MRB (QSI042) Approval
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Description Work Order Deviation	Completed By
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S041464

Lower Cutter Assembly

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

hand / Supervisor
 Approval Verification

PART NO: 647.7501
Original Serial #: S041464
Revision:
Operation:
Change No:

Start up Operation 02/12/18
Job No: 172052

IC / QA Coordinator
 Approval

Root Cause			
Environment ☐	No Re-verification ☐	OTHER :	
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐		
Tribal Knowledge ☐	Rushing ☐		
LOA ☐	Product Improvement ☐		
Substation ☐	Process Improvement ☐		
Past Expiry Date ☐	Manufacturing Process ☐	Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence	
Misidentified ☐	Past Due ☐		

647.7813	1	9	0
647.7814	1	8	0
647.7815	1	9	0
647.7816	1	9	0
647.7817	1	8	0
MS21042-08	13	0	0
MS21042-3	3	506	0
MS27039-08-19	7	769	0
MS27039-08-24	6	112	0
MS27039-1-19	3	260	0
NAS1149F0332P	6	3,819	0
NAS1149FN832P	26	4,390	0

Part Specifications

Specifications could not be found.

Plex 2/12/18 12:28 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																



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Canada

Master Unit 000769

Tel (613) 632-5200

Containers on Master Unit 000769				
Serial No	Part No	Customer Part No	Status	Quantity
S041432	646.3015		Allocated	2
F163287	647.7601		Allocated	1
S041433	647.7810		Allocated	1
S041435	647.7811		Allocated	1
S041439	647.7813		Allocated	1
S041440	647.7814		Allocated	1
S041442	647.7815		Allocated	1
S041444	647.7816		Allocated	1
S041445	647.7817		Allocated	1
S041455	MS21042L08		Allocated	13
S041456	MS21042L3	MS21042L3	Allocated	3
S041457	MS27039-08-19		Allocated	7
S041458	MS27039-08-24		Allocated	2
S041459	MS27039-08-24		Allocated	4
S041460	MS27039-1-19		Allocated	3
S041461	NAS1149F0332P		Allocated	6
S041462	NAS1149FN832P		Allocated	26